

Date: Wednesday, 3/28/2007 12:40:15 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INNER AFT SADDLE
Job Number : 31531	
Estimate Number : 11082	
P.O. Number : N/A	Part Number : D5957
This Issue : 3/28/2007 S.O. No. : N/A	Drawing Number : D5957 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28083	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 4/15/2007 Qty: 6 Um: Each
Checked & Approved By : <u>[Signature] 07.03.28</u>	
Comment : Est Rev: E Re-Format 05-11-29 JLM	
Est Rev: F ecn826 06.12.06 ec	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: B25355

J.F. 07/04/05

2.0

HAAS3

HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

J.L. J.F. 07/04/05 (7)

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.L. J.F. 07/04/05 (7)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.04.09 (7)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.L. 07/04/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/17	2.0	Dimension , 313" is to thin. Actual Dimension is 1288" to 1305"	 05/04/17	Acceptable per attached email.	J.F. 07/04/17	 07/04/17	 05/04/17	 07/04/17

NOTE: Date & initial all entries

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Drawing Name: INNER AFT SADDLE

Job Number: 31531

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-04-18 (7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/4/18 (7)



59

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/4/18 59

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(7) 07/04/19

Job Completion



07-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	3153
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	Ø.439"	Ø.439"	Ø.439"		
B	1.745	1.755		1.750	1.750"	1.750"	1.750"		
C	5.245	5.255		5.249	5.249"	5.249"	5.249"		
D	6.995	7.005		6.998	6.998"	6.998"	6.998"		
E	5.745	5.755		5.750	5.750"	5.750"	5.750"		
F	4.745	4.755		4.750	4.750"	4.750"	4.750"		
G	0.313	0.318		.315	Ø.315"	Ø.315"	Ø.315"		
H	1.522	1.532		1.527	1.527"	1.527"	1.527"		
I	3.048	3.058		3.053	3.053"	3.053"	3.053"		
J	4.575	4.585		4.580	4.580"	4.580"	4.580"		
K	0.313	0.318		.315	Ø.315"	Ø.315"	Ø.315"		
L	0.495	0.505		.501	.501"	.501"	.501"		
M	0.490	0.510		.500	.500"	.500"	.500"		
N	1.865	1.885		1.875	1.875"	1.875"	1.875"		
O	7.990	8.010		7.998	7.998"	7.998"	7.998"		
P	2.240	2.260		2.250	2.250"	2.250"	2.250"		
Q	0.307	0.312		*.311	.311"	.311"	.311"		
R	0.760	0.765		.764	.764"	.764"	.764"		
S	0.490	0.510		.498	.498"	.498"	.498"		
T	1.625	1.645		1.631	1.631"	1.627	1.626"		
U	2.000	2.020		2.005	2.010"	2.010"	2.010"		
V	0.023	0.043		.033	.033"	.033"	.033"		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L. / J.F.
Date:	07/04/05

Audited by:	SA
Date:	07.04.05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	31531
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1	

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L	0.495	0.505		0.501	0.501	0.501			
M	0.490	0.510		0.502	0.502	0.502			
N	1.865	1.885		1.875	1.875	1.875			
O	7.990	8.010		7.996	7.996	7.998			
P	2.240	2.260		2.250	2.250	2.250			
Q	0.307	0.312		0.311	0.310	0.311			
R	0.760	0.765		0.764	0.764	0.764			
S	0.490	0.510		0.498	0.499	0.500			
T	1.625	1.645		1.626	1.626	1.626			
U	2.000	2.020		2.010	2.010	2.010			
V	0.023	0.043		0.033	0.033	0.033			
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

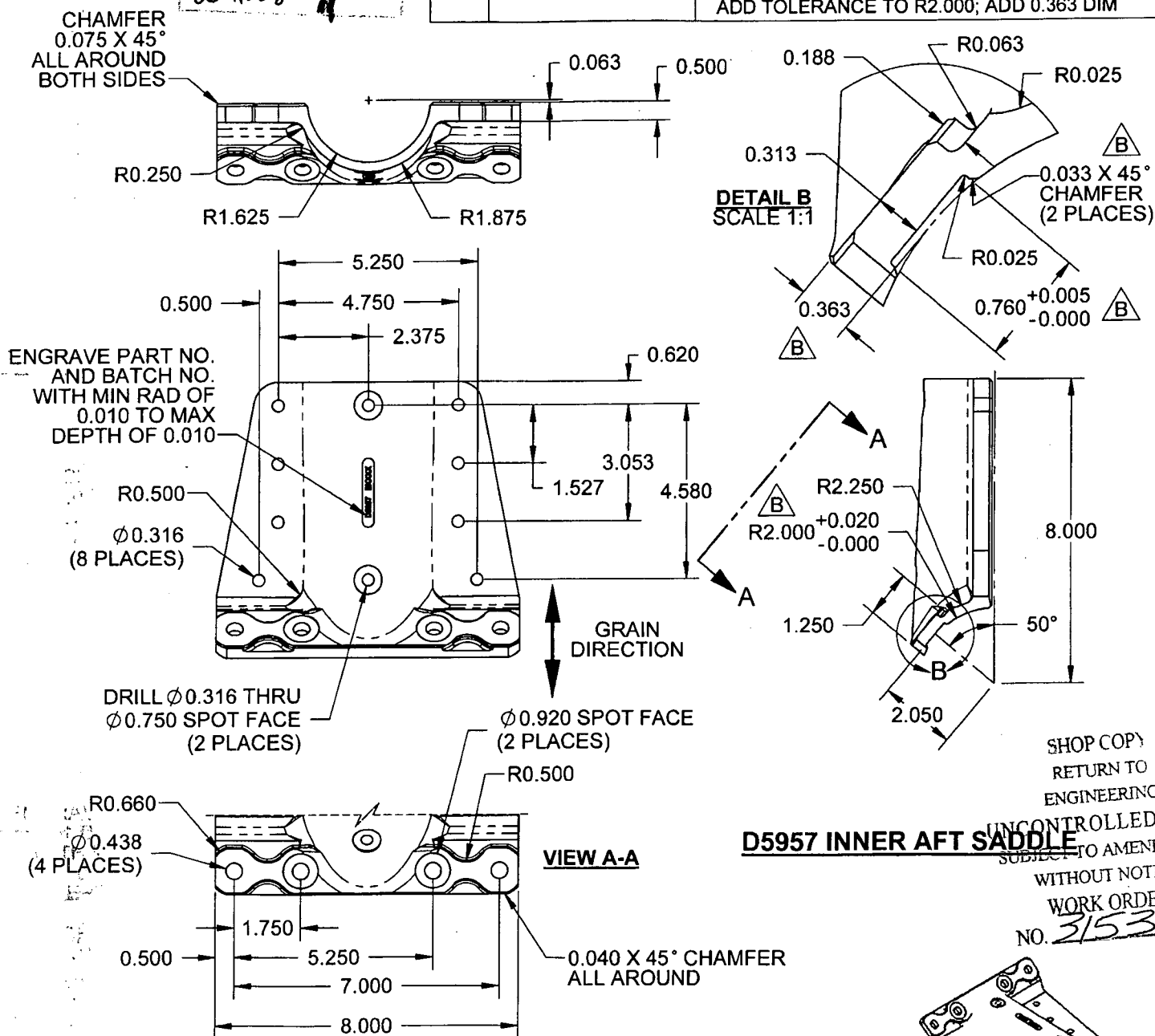
Measured by:	J.F.
Date:	07/04/07

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
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C	06.11.20	Added dimension V	KJ/JLM	
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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5957
DATE 06.11.07	TITLE INNER AFT SADDLE	REV. B SHEET 1 OF 1
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8

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S Shahbazian

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 16, 2007 9:58 AM
To: 'S Shahbazian'
Cc: 'Jason Murdoch'; 'L Lacelle'
Subject: RE: Undersized dimensions

Acceptable deviation.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Friday, April 13, 2007 5:44 AM
To: Shepherd, David
Subject: FW: Undersized dimensions

David,
Did you have a chance to look at this?

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: April 9, 2007 11:53 AM
To: Shepherd, David
Subject: Undersized dimensions

David,
We have a saddle (D5957) that has been machined under sized at the locations shown on the attached drawing. As you can see the dimension 0.313 on four different locations are:

- Dimension 0.313 is 0.305 near outboard hole
- Dimension 0.313 is 0.286 near second hole next to outboard hole
- Dimension 0.313 is 0.287 near next hole
- Dimension 0.313 is 0.304 near fourth hole

The two dimensions 0.305 and 0.304 near outboard holes are with in the tolerance; however the other two dimensions near inside holes are undersized.

I think it is acceptable, what do you think?

Thanks
Serge

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.446 / Virus Database: 269.3.0/758 - Release Date: 4/12/2007 11:52 AM

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.446 / Virus Database: 269.4.0/759 - Release Date: 4/12/2007 7:58 PM

16/04/2007